

BLUE

Dart Aerospace Ltd.

Date: Tuesday, 19/08/2008 1:05:02 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE
 Job Number : 41396
 Estimate Number : 10553
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206667103 *BL*
 First Issue : / / Type : CROSSTUBES Drawing Number : D206-667-143 REVB + *DSI 9415 Rev A*
 Previous Run : 41395 Project Number : N/A
 Material : B
 Due Date : 05/09/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *JUD 08.8.19*
 Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
 Skidtubes KJ/JLM
 Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD
 verified by:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL

*JUD 08.8.28*

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

8 08/08/06

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D206667103TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *36968**DP 8-8-29*

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206B-fw and Folio FT

*DD 8-8-29**(PTO)*

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

25 08-09-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.09.02	4.0	QC 15 required After bending.						
	↓	Add to Estimate, perm change.	PE	06.09.18		06.09.02	06.09.02	
06.09.02	4.1	QC 15 inspection.		06.09.02	①	06.09.02	06.09.02	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 1:05:02 PM
User: Julie Lepocq

3WE
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 41396

Part Number: D206667103

BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143.

Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143.

10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143

Inside of Cuff(Donot engrave on outside of tube)

25
08-09-03

ANM
8-9-3

FT 08-09-03

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



ANM
8-9-3



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 08/09/04 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/04 (1)

9.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 7097 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 208/09/08 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

2 8/9/8 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 1:05:02 PM
User: Julie Lepocq

BLUE
Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 41396

Part Number: D206667103 *BL*

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6

DIMENSIONAL CHECK



2008-09-10 *(1)*



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Iron as per QSI 005 4.2

Del Fleet Blue + Clear Del Fleet
B 105918 B 107919

2T 08-09-10

13.0

QC14

INSPECT SPRAY PAINT



2008-09-11 *(1)*



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

14.0

D3595075395

RUBBER CUSHION .75" x 3.95



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION .75" x 3.95

B 40220

2T 08-09-11

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

37941

2T 08-09-10

16.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate

37341

2T 8-09-10

17.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support

41301

2T 08-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 1:05:02 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 41396

Part Number: D206667103 **BL**

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet **107008**

2708-09-40

19.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp **17501**

2708-09-11

20.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2708-09-11

2-Install supports and clamps as per Dwg D4206-667-143. Torque clamps to 80-100 in lb

2708-09-12 (1)

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint. **2708-09-10**

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2708-09-15 (1)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

23.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: **1107013**

8/9/15

(1x)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 1:05:02 PM
User: Julie Leacock

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 41396

Part Number: D206667103 **BL**

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: **M108161**

SP

25.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-7A

Bolt

M107378

SP

26.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-30A

Bolt

M105144

SP

27.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M108672

8/9/15

SP

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808102/16

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-867-103

Location:

PPP Rev: **D**

8/8/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 1:05:02 PM
User: Julie Lepocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 41396

Part Number: D206667103

BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/17
JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

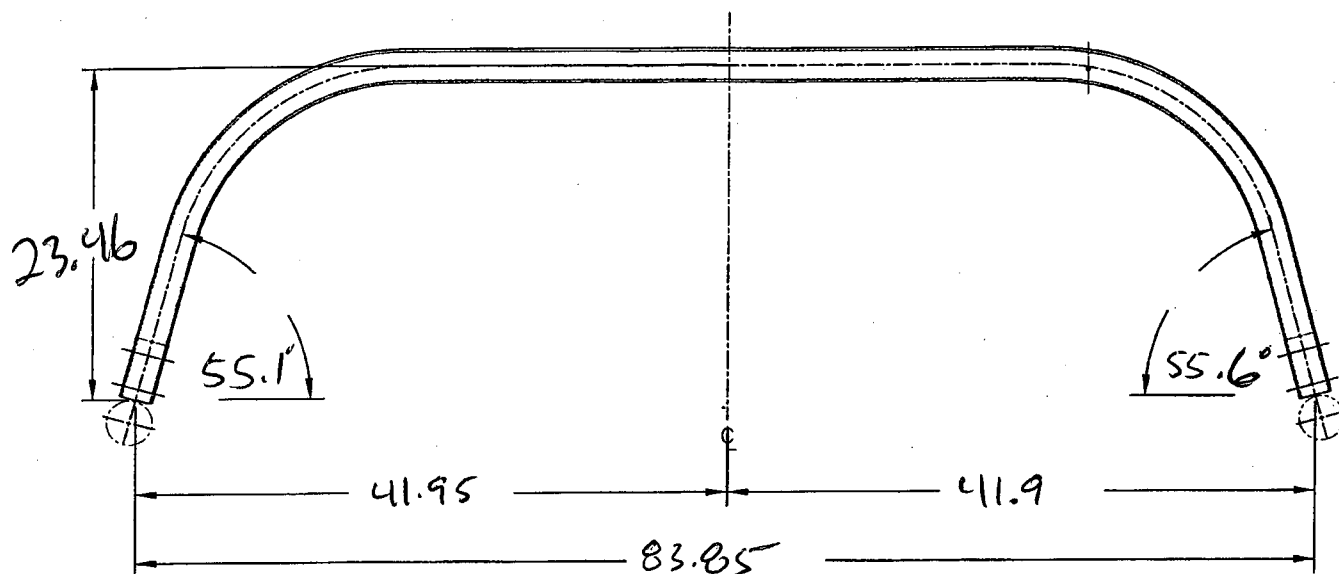
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	41394
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	06.09.02
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

PH 05.08.20
UNDER REVIEW
05.08.10 PH
re draw detail F

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

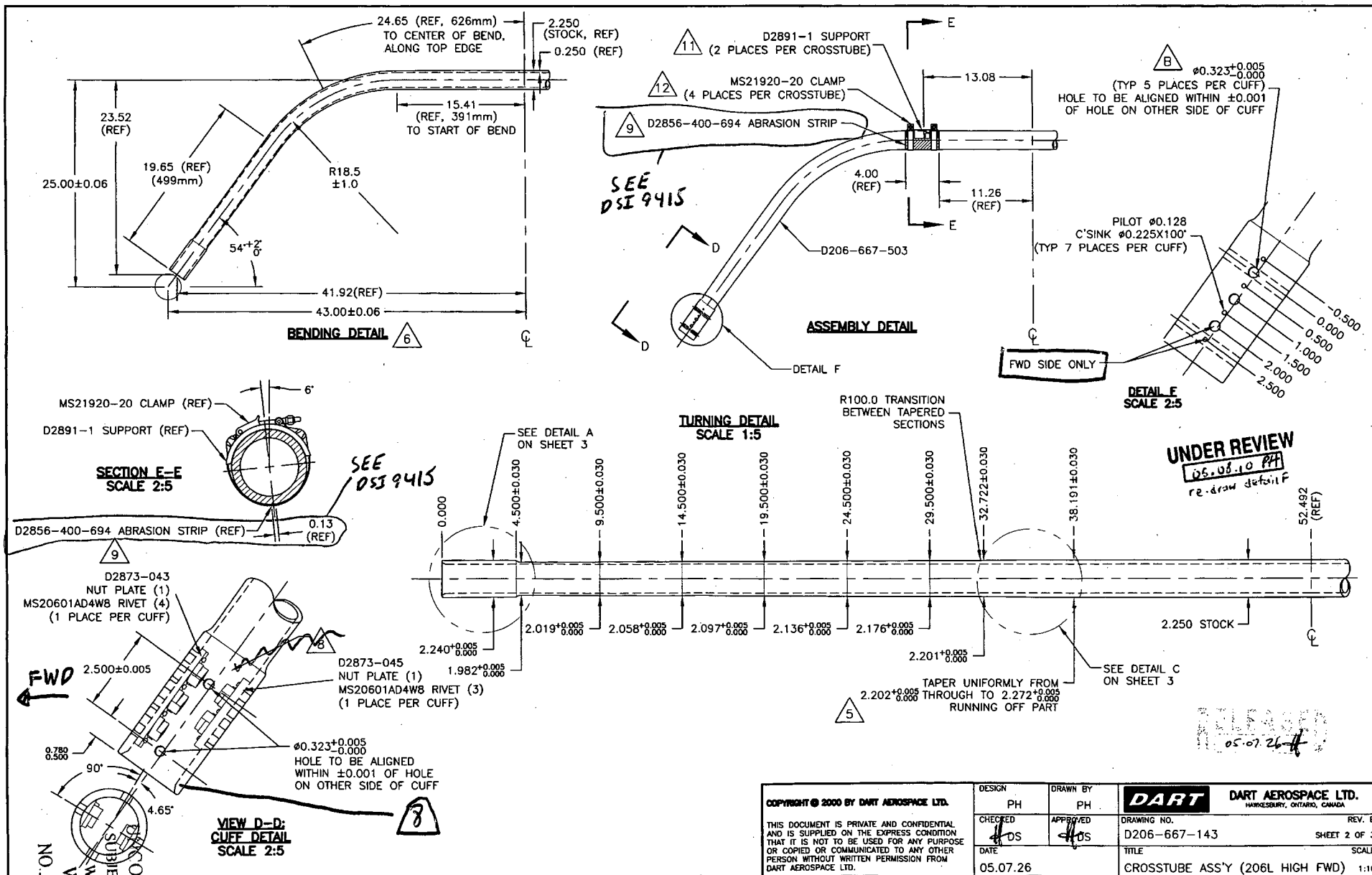
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

INSIDE OF
CUFF
THESHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41390

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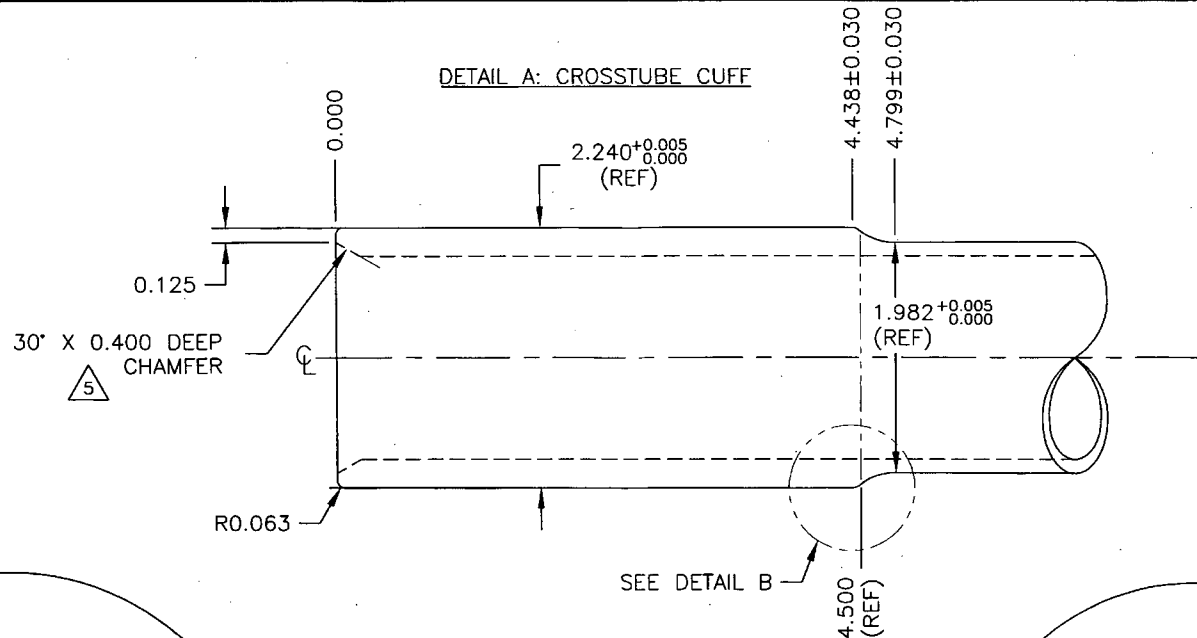


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DESIGN	PH	DRAWN BY	PH
CHECKED	PH	APPROVED	PH
DATE	05.07.26		

DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
DRAWING NO. D206-667-143	REV. B SHEET 2 OF 3
TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:10



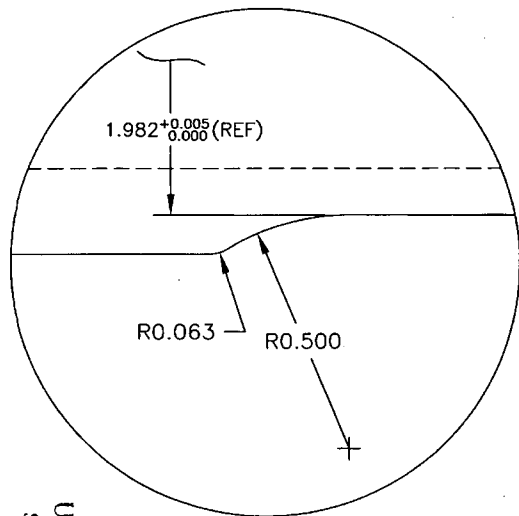
05.07.26 #

UNDER REVIEW

06.08.10 PH

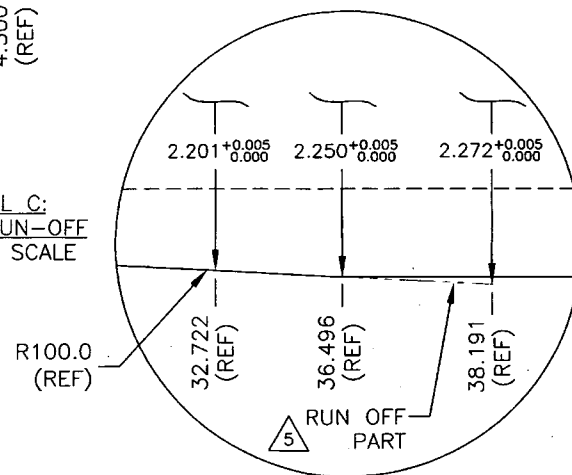
re-draw detail F

03.08.20



DETAIL C: TAPER RUN-OFF

NOT TO SCALE



COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	REV. B
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	PH	APPROVED	PH		SHEET 3 OF 3
DATE		05.07.26		DRAWING NO.		D206-667-143	SCALE
TITLE		CROSSTUBE ASS'Y (206L HIGH FWD)					1:1

NO. 27512

WORK ORDER

WITHOUT NOTICE

SUBJECT TO AMENDMENT

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41396

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2
REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY

For D206-667-101/-201/-103/-203 or D407-667-105 cross tubes at CHG 003 or later, the D2856-400-694/-773 abrasion strip has been removed, the center D2891-1 or D2892-1 support has been bonded onto the crosstube using Magnabond 6398 and D3595-075-395/-450 Rubber Cushions have been installed underneath the MS21920-20/-22 Clamps. Amend parts list of the IIN-D206-667 section 5 and ICA-D206-667 Section 32.8 as follows:

REMOVE:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
13	2	2	2		2	D2856-400-694	ABRASION STRIP
14				2		D2856-400-773	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	QTY -103	QTY -203	QTY -105	PART NUMBER	DESCRIPTION
24	4	4	4		4	D3595-075-395	RUBBER CUSHION
25				4		D3595-075-450	RUBBER CUSHION

To prevent the supports from shifting on the D206-667-101/-201/-103/-203 or D407-667-105 crosstubes at CHG 002 or earlier, the D2891-1/D2892-1 supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D206-667 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty (2) MS21920-20/-22 clamps from the crosstube that fasten the D2891-1/D2892-1 supports to the crosstube.
- 3) Remove the D2856-400-694/-773 abrasion strip from the crosstube per section 32.5 of ICA-D206-667.
- 4) Inspect the crosstube surface underneath the support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D206-667. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D206-667. Touch up finish per item 5.3.9 of the 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath the D2891-1/D2892-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1/D2892-1 support on the crosstube using MS21920-20/-22 Clamps. Install a D3595-075-395/-450 Rubber cushion underneath each MS21920-20/-22 Clamp. Torque clamps 80-100 in-lb. Let the D206-667-101/-201/-103/-203 or D412-667-105 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	HS	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	E	DSI 9415	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

7) Re-install the D206-667-101/-201/-103/-203 or D412-667-105 crosstube per section 32.2 of ICA-D206-667.

For customers who would like to upgrade their D206-667-101/-201/-103/-203 or D412-667-105 crosstubes from CHG 002 or earlier to CHG 003, the following kit can be obtained from Dart:

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9415-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-101/-201/-103 OR D407-667-105)
	X	DSI 9415-013	CROSSTUBE SUPPORT CHANGE (USABLE ON D206-667-203)
4		D3595-075-395	RUBBER CUSHION
	4	D3595-075-450	RUBBER CUSHION

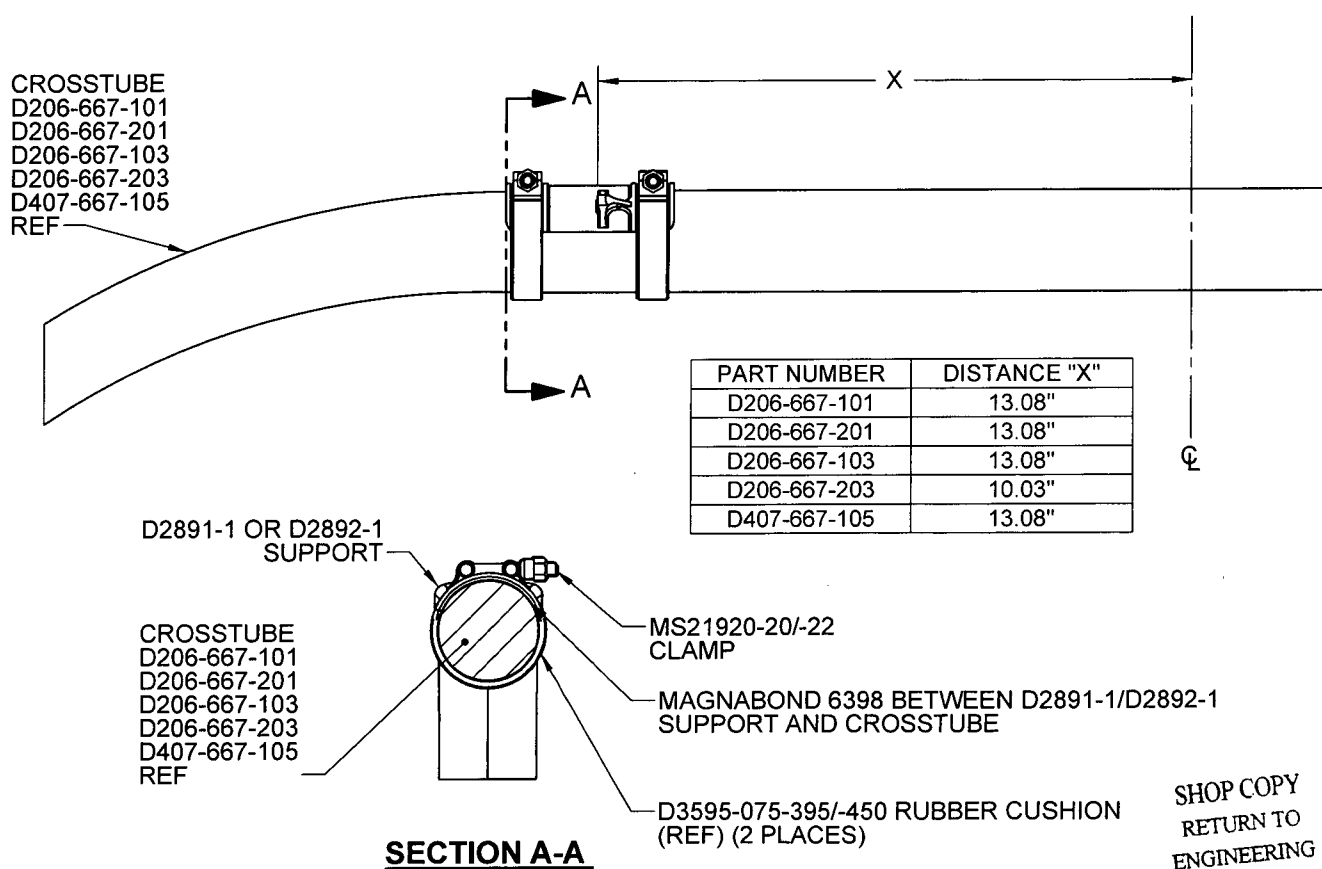


FIGURE 1 - CROSSTUBE SUPPORT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 08.05.26
CERT. NO.: SH01-5
ISSUE NO.: 3

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	HS	
CHECKED	PH	DRAWING NO. REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9415 SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE NTS
DATE	08.05.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

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WORK ORDER
NO. 41396



LIQUID PENETRANT TEST REPORT

P - 1464 1

CLIENT	DART AEROSPACE	DATE	SEP 5, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1464	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	POWVO NO.	7097				
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY, ONT.				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	206L FWD X TUBE, 206B AFT X TUBE, 212/205 HIGH FED X TUBES, 407 FWD X TUBE						
ITEM(S) EXAMINED	JOB #'S: 41395, 41396, 41403, 41404, 41539, 41540, 40786, 40787, 41405, 41406						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-TECH2	REV./DATE
'PART NO. D206667103/D206667202/D212664101/D407667105 MATERIAL ALODINED ALUM. THICKNESS				
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE				

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT ZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL JUNE 16 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL
SURFACE ON:

206B AFT X TUBE JOB#S: 41539, 41540.

212/205 HIGH FED X TUBES JOB#: 40786, 40787.

407 FWD X TUBES JOB#S: 41405, 41406.

206L FWD X TUBE JOB#S: 41395, 41396, 41403, 41404.

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E 19943	
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:	
NAME (PRINT):	JASON HEWETT	NAME INITIALS	
	1 ST TECHNICIAN		
CGSB LEVEL	2	CGSB LEVEL	
CGSB REG. NO	6156	CGSB REG. NO	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

BLUE

Date: Tuesday, 19/08/2008 1:05:02 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FWD X-TUBE
Job Number	: 41396	Part Number	: D206667103 <i>BL</i>
Estimate Number	: 10553	Drawing Number	: D206-667-143 REV B + <i>DSI 9415 Rev A</i>
P.O. Number	:	Project Number	: N/A
This Issue	: 19/08/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : CROSSTUBES	Due Date	: 05/09/2008 Qty: 1 Um: Each
Previous Run	: 41395		
Written By	:		
Checked & Approved By	: <i>JUL 08.8.19</i>		
Comment	Est Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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08/09/15 Label red+white



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

3.0	D206667103TRN	Crosstube Turning DetailL
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *36968*

DP 8-8-29

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206B-fw and Folio FT

DP 8-8-29

(P70)

5.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

21 0809-03